

Date: Monday, 16/03/2009 2:00:57 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 46516	Part Number	: D22303
Estimate Number	: 10256	Drawing Number	: D2230 REV F
P.O. Number	:	Project Number	: N/A
This Issue	: 16/03/2009	Drawing Revision	: F
Prsht Rev.	: NC	Material	:
First Issue	: //	Due Date	: 03/04/2009
Previous Run	: 45915	Qty:	160
Written By	:	Um:	Each
Checked & Approved By	: <u>JUL 09.03.14</u>		
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion 	
Comment: Qty.: 0.0717 f(s)/Unit Total : 11.4744 f(s) Lug Extrusion D2423 Batch: <u>B458001</u> J.F. 09/03/22			
2.0	D22303P	LUG 	
Comment: Qty.: 1.0000 Each(s)/Unit Total: 160.0000 Each(s) LUG			
3.0	BAND SAW	BAND SAW 	
Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: <u>B45800</u> J.F. 09/03/22 164			
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. PTO → J.A 09/03/24 88 09/03/23 167			
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.A 09/03/24 88 09/03/23			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2230-3 PAR #: N/A Fault Category: Prod/Machined Parts NCR? Yes No DQA: Date: 09/04/06

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/23	4.0	First part thickness dimension was too thin .750 ± .010 was .633. R.C. Bad origin, operator error	DSIUR2	Scrap & replace qty 1 B 45800	SR 09/03/23	J.F. 09/03/23	DSIUR2	DSIUR2
		One part is under size dimension of .750 ± .010 R.C. Blank material was cut crooked. in 300sp4.	DSIUR2	- Replace B 45800 - scrap. Revise blank cut size on seq. 3.0	SR 09/03/23	J.F. 09/04/06	DSIUR2	DSIUR2
09/03/24	4.0	1 part scrap because Blank was cut too thin	SR	Just off. ab	N.A 09/03/24	J.F. 09/04/06		

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 46516

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J-F. 09/03/27

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9.0 QC9

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd 09/03/30

167

10.0 POWDER COATING

POWDER COATING



m110939

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 15:35

OVEN TEMPERATURE: 300°

FINISH TIME: 16:05

x167

cmol Fd

09/03/30

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



167

Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

fd 09-03-31

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST476

18096461 x67

13.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/02 fd

Comment: FINAL INSPECTION/W/O RELEASE

mf 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	HU510
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>J.S.</u> / J.A. 09	Audited by:	<u>J.F.</u>	Prototype Approval:	N/A
Date:	09/03/23	Date:	09/03/27		Date:

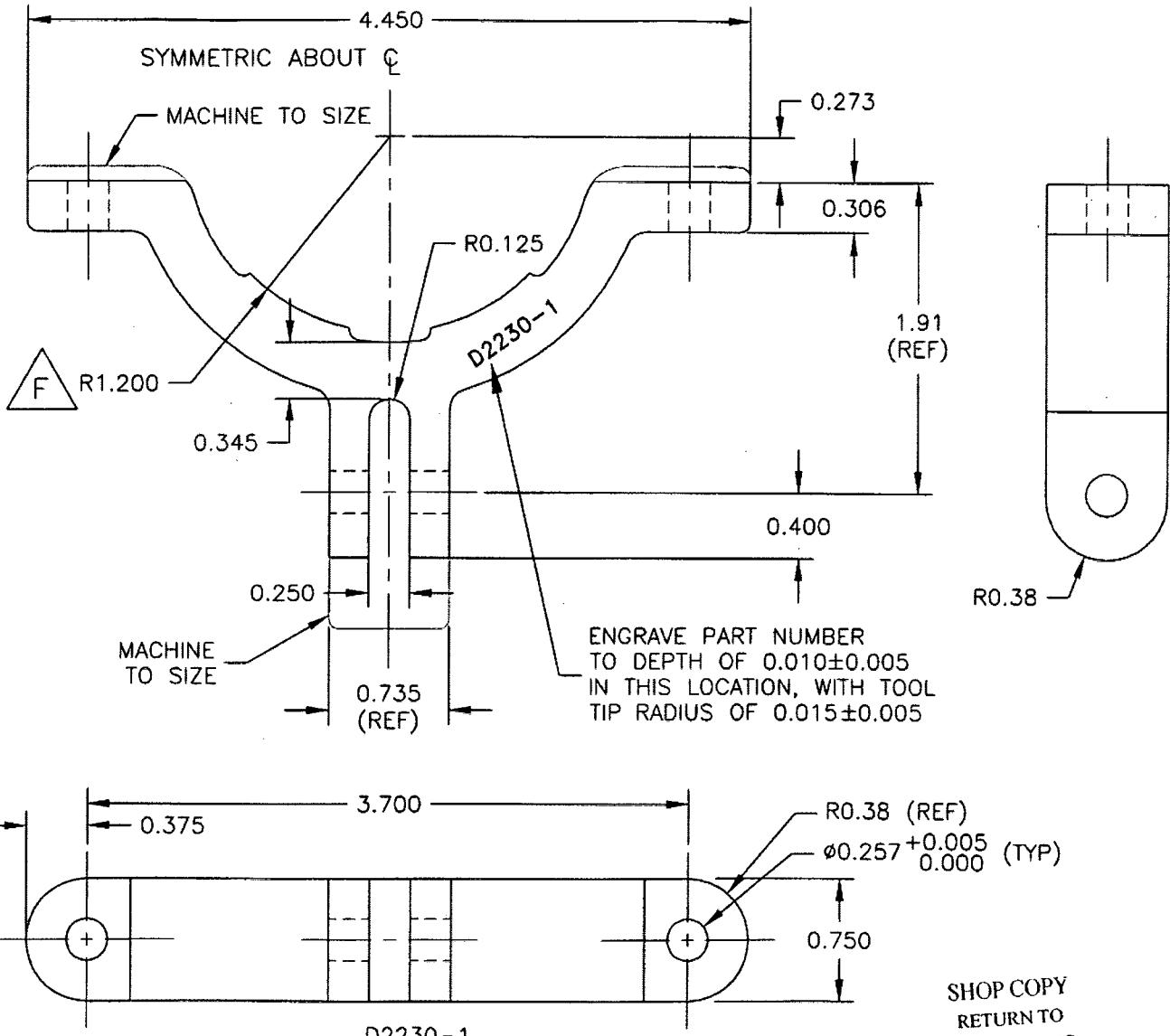
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	TT

DART



DESIGN <i>IP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2230
DATE 99.12.13	TITLE MOUNTING LUG	REV. F SHEET 1 OF 2 SCALE 1:1
C D E F	94.03.30 95.01.04 95.01.04 99.12.13	RE-DESIGN RE-DESIGN RE-DESIGN REDESIGN; R1.200 WAS R1.100

RELEASED
99.12.21 PS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

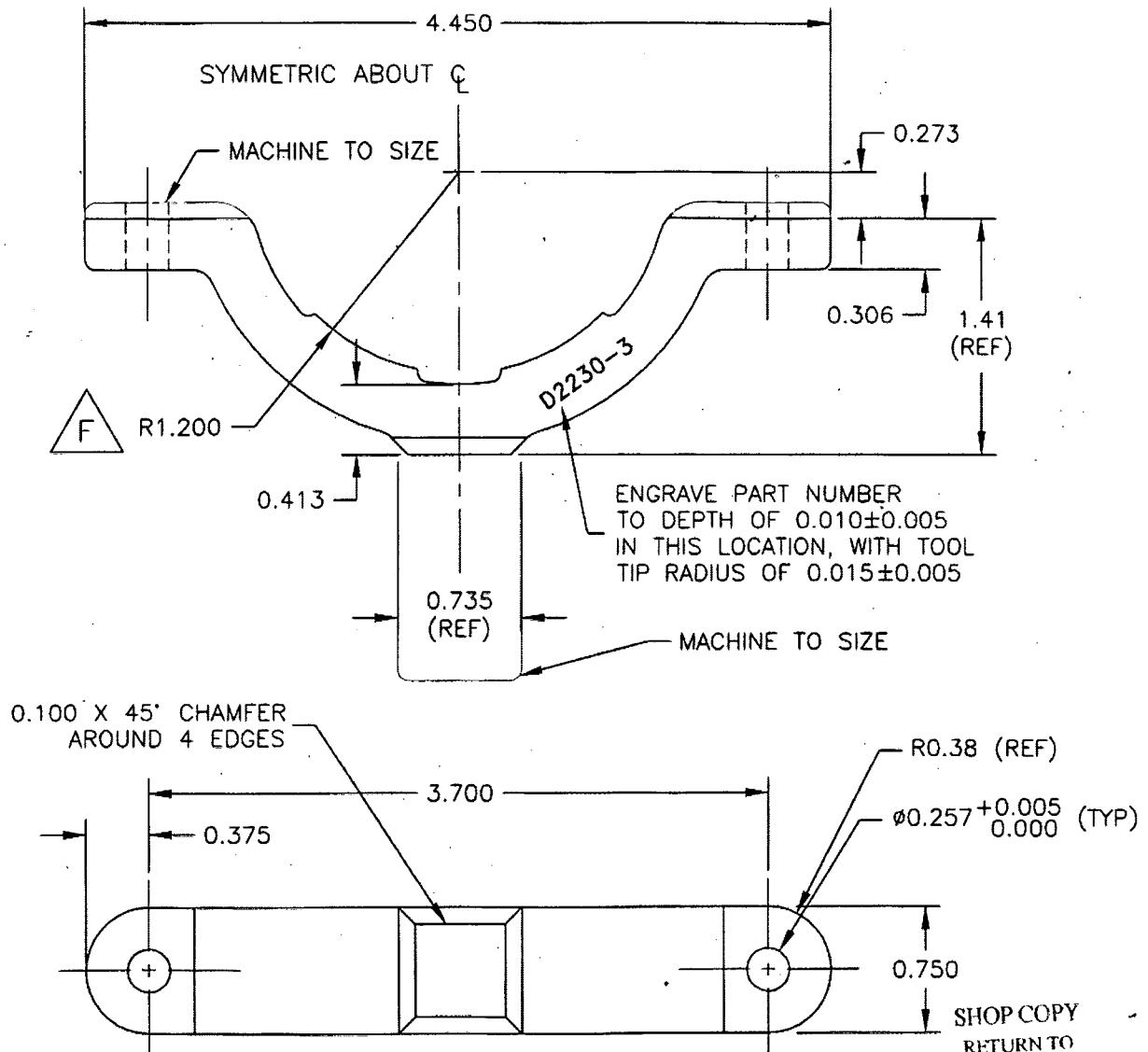
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. W0516

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 2 OF 2
99.12.13		SCALE 1:1

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.